

Date: Monday, 02/03/2009 9:09:39 AM
 User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : END FITTING ASS'Y RH
 Job Number : 46157
 Estimate Number : 13343
 P.O. Number :
 This Issue : 02/03/2009 S.O. No. :
 Prsht Rev. : NC Part Number : D3763044
 First Issue : / / Type : LARGE FAB ASSY Drawing Number : D3763 REVB
 Previous Run : 42956 Project Number : N/A
 Material :
 Due Date : 09/03/2009 Qty: 10 Um: Each
 Written By :
 Checked & Approved By : umf 09-03-02
 Comment : Est Rev:A 08-05-20 new issue DD verified by:ec
 Est Rev:B 08-07-18 revB as per dwg DD verified by:EC
 Est Rev:C 08-08-11 add chemical coat and qc3 DD verified by:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

2.0 ~~End Fitting~~ End Fitting



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)
 End Fitting
 batch: B42732 = 8x
SP 09.03.19.

3.0 ~~D37636~~ Tube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)
 Tube
 batch: B42735 = 10
SP 09.03.19.

4.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1
 1-make a 0.063" chamfer on D3763-1 fitting before ass'y
 2-assemble and tack weld as per dwg D3763 using locating pin DT9039
 *****look at dwg before assembling parts (RH) *****
 *****remove pin before welding*****

3-weld as per dwg D3763, QSI004

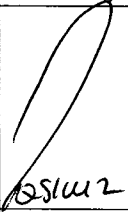
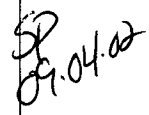
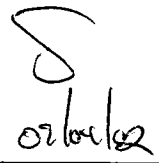


Alum. rod Batch: M 104855

SP 09.03.19

(10x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3763-044 PAR #: N/A Fault Category: Prod/Eng. Lrg NCR: Yes No DQA: A Date: 09/04/03
 Resolution: SCIP Disposition: SCIP QA: N/C Closed: A Date: 09/04/03

NCR: <u>46157</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
090819	4.0	All parts are scrap. welds cracked in between the D3763-1's. R.C. Process		Scrap & destroy. Review weld process: to prevent.				

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: END FITTING ASS'Y RH

Job Number: 46157

Part Number: D3763044

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC9

VISUAL WELDING INSPECTION



Q

Comment: VISUAL WELDING INSPECTION

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify with Dart part # using a fine point permanent marker and Stock
Location: _____

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-04-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

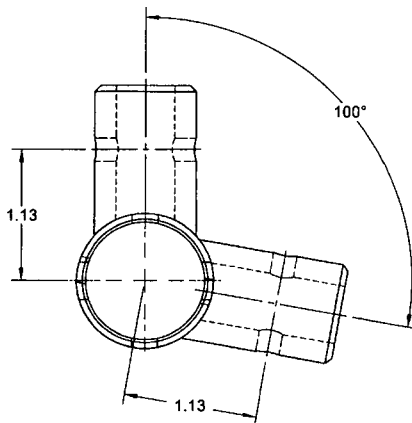
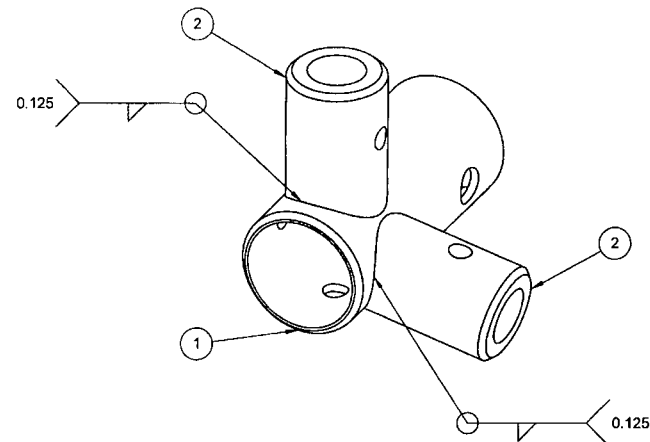
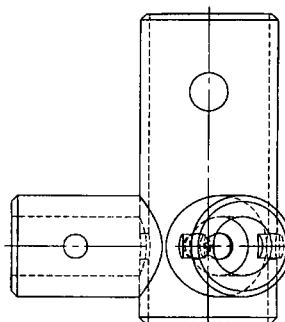
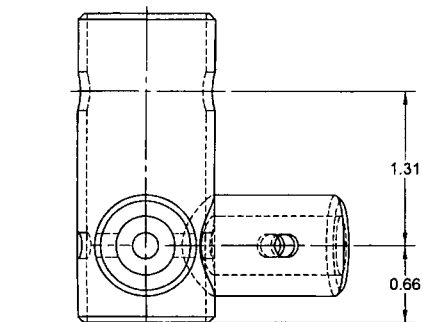
8 7 6 5 4 3 2 1

D

C

B

A



W0
46157

D3763-044 END FITTING ASSY, RH

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-044)
1	D3763-6	TUBE	1
2	D3763-1	FITTING	2

RELEASED
08-07-10

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT ASSEMBLY PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.05 lbs
 - 8) WELD: PER DART QSI 004

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	HS	DRAWING NO. D3763	REV. B
MFG. APPR.	HS	SHEET 3 OF 9	
APPROVED	HS	TITLE	SCALE
DE APPR.	HS	END FITTING	NTS
DATE	08.06.23	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

Dart Aerospace Ltd

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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